

# Work Order ID 71471

Tuesday, July 05, 2011 8:36:51 AM



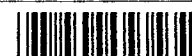
Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 7/4/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-07-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP205-633-011 CHG001

5 u los los

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/13 GW sf

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5 u los los

XU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71471**

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Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 7/4/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location:								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

CK 11/08/09

11-08-9  
(u)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 71471

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step



Start Date: 7/4/2011

Required Date: 7/18/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 ☐ RF ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A 		Purchased	No			110	Each	163.0000	1	6			
-------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

*S46 Bolt*

Location	Loc Qty	Loc Code
ST357	163	
116914	4	
117619	9	
117872	150	

AN4-5A 		Purchased	No			110	Each	248.0000	2	12			
------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

*S46 Bolt*

Location	Loc Qty	Loc Code
ST355	200	
117508	200	
ST356	48	
116549	48	

AN4-6A 		Purchased	No			110	Each	1,058.000	2	12			
------------	--	-----------	----	--	--	-----	------	-----------	---	----	--	--	--

*S46 Bolt*

Location	Loc Qty	Loc Code
ST356	858	
116400	258	
116924	400	
117872	200	
ST358	200	
117514	200	

*Handwritten notes and signatures:*

- Next to AN4-14A: *6*
- Next to AN4-5A: *12*, *M116605*
- Next to AN4-6A: *12*, *11/10/35*, *ax*
- Bottom right: *12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 71471

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 7/4/2011

Required Date: 7/18/2011

Start Qty: 6.00

Required Qty: 6.00

AN4-7A

Purchased

No

110

Each

224.0000

2

12



Bolt

Location

Loc Qty

Loc Code

ST356

224

117443

24

117514

200

AN5-14A

Purchased

No

110

Each

74.0000

1



Bolt

Location

Loc Qty

Loc Code

ST338

74

115374

74

AN5-6A

Purchased

No

110

Each

55.0000

1



Bolt

Location

Loc Qty

Loc Code

ST337

55

117313

5

117688

50

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

15

90



Washer

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

4

24



Washer

Reste 2 Autke

M11

M118206

11/8/35/60

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 71471

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 7/4/2011

Required Date: 7/18/2011

Start Qty: 6.00

Required Qty: 6.00

D2021-101

Manufactured No

110

Each

30.0000

1



Eyebolt

Location

Loc Qty

Loc Code

ST004

30

69527

30

D2022-101

Manufactured No

110

Each

86.0000

2



Spacer

Location

Loc Qty

Loc Code

ST504

86

69532

26

69824

60

D2022-103

Manufactured No

110

Each

35.0000

2



Spacer

Location

Loc Qty

Loc Code

ST005

35

69550

35

D2562-001

Manufactured No

110

Each

5.0000

1



Strut

Location

Loc Qty

Loc Code

ST264

5

68899

5

D2563

Manufactured No

110

Each

0.0000

1



Step Weldment Assembly

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 71471

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 7/4/2011

Required Date: 7/18/2011

Start Qty: 6.00

Required Qty: 6.00

D2565-101

Manufactured No

110

Each

12.0000

1

6



Strut

Location

Loc Qty

Loc Code

ST270

12

68900

4

70190

8

D2565-103

Manufactured No

110

Each

10.0000

1

6



Strut

Location

Loc Qty

Loc Code

ST270

10

68901

2

69526

8

D2565-105

Manufactured No

110

Each

11.0000

1

6



Strut

Location

Loc Qty

Loc Code

ST270

11

69517

11

D2565-107

Manufactured No

110

Each

9.0000

1

6



Strut

Location

Loc Qty

Loc Code

ST270

9

69522

9

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 71471

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 7/4/2011

Required Date: 7/18/2011

Start Qty: 6.00

Required Qty: 6.00

D2565-109

Manufactured No

110

Each

13.0000

1



Strut

Location

Loc Qty

Loc Code

ST270

13

64797

1

69524

12

D2565-111

Manufactured No

110

Each

21.0000

1



Strut

Location

Loc Qty

Loc Code

ST270

21

68904

4

69523

10

69898

1

69949

1

70203

5

MS21042L4

Purchased No

110

Each

4,627.000

8



Nut

Location

Loc Qty

Loc Code

ST300

4627

117441

2338

117601

789

117885

1500

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 71471

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step



Start Date: 7/4/2011

Required Date: 7/18/2011

Start Qty: 6.00

Required Qty: 6.00

MS21042L5

Purchased No

110

Each

1,443.000

2

12



Nut



11/10/13

62

## Location

## Loc Qty

## Loc Code

ST300

1443

116105

5

116548

240

117441

498

117591

100

117611

100

118179

500

3

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LISTS

## 5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21